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मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 8670 (1977): Screwdrivers for Hexagon Insert Bits [PGD  
5: Assembly Hand Tools]



“ज्ञान से एक नये भारत का निर्माण”

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“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”



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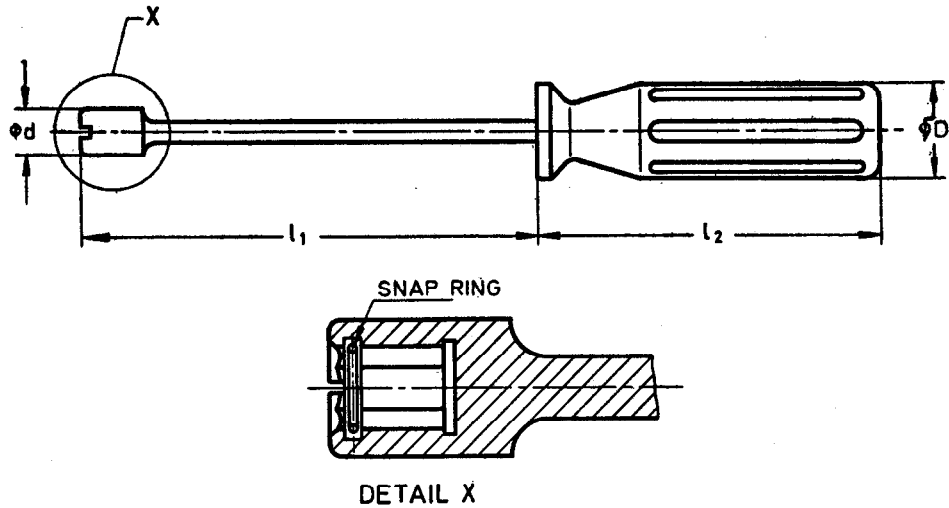




Indian Standard

SPECIFICATION FOR SCREWDRIVERS  
FOR HEXAGON INSERT BITS

1. **Scope** — Covers requirements for screw drivers for hexagon insert bits.
2. **Types**
- 2.1 *Type A* — Screw drivers for hexagon insert bits without magnet and with snap ring.
- 2.2 *Type B* — Screw drivers for hexagon insert bits with magnet and with or without snap ring.
3. **Dimensions**



All dimensions in millimetres.

Female Hexagon*		d	l <sub>1</sub>	l <sub>2</sub>	D	Testing Torque
Form	Nominal Dimension	Max	Max			N.m Min
D	6.3	12	120	90	25	14.7
D	8.0	15	170	120	37	14.7

\*According to IS : 8669-1977 'Dimensions for hexagon drive ends for power tools.'

4. **Material**
- Type A* — Suitable steel meeting the requirements laid down in 5 and 8.
- Type B* — Copper beryllium alloy or any other suitable material meeting the requirements laid down in 5 and 8.
- 4.1 *Handles* — The wooden handles shall conform to the requirements specified for Class 5 handles in IS: 620-1975 'General requirements for wooden tool handles (*third revision*)'. Suitable plastics may also be used depending upon the agreement between the supplier and the purchaser. One of the suitable plastics for this purpose is cellulose acetate conforming to IS: 2543-1964 'Specification for cellulose acetate moulding and extrusion materials'.
- 4.2 *Ferrules* — The ferrules for wooden handles shall be manufactured from steel conforming to Type B of IS: 513-1973 'Specification for cold rolled carbon steel sheets (*second revision*)'.
5. **Hardness**
- 5.1 All steel parts except magnet core (in case of *Type B*) shall have hardness of 510 HV ( $\approx 50$  HRC), Min.

5.2. When provided with magnet, all metal parts other than steel shall have hardness of 390 HV ( $\approx 40$  HRC), Min.

6. **Workmanship and Finish** — The tools shall be free from burrs, ash and cracks. The heat treatment shall be followed by a surface treatment like blasting, grinding or polishing. The metal parts may be blank, burnished or galvanized according to manufacturer's choice.

7. **Designation** — The screw driver of Type A with female hexagon form D and nominal dimension 8 mm shall be designated as:

Female Hexagon Screw Driver A — D8, IS : 8670

8. **Torque Test** — After application of testing torque, the screw driver shall not show any permanent deformation or other damage like cracks, rupture, etc likely to affect the function.

## 9. Sampling

9.1 Unless otherwise agreed to between the buyer and the seller the sampling inspection procedure as given in IS : 2500 ( Part I )-1973 'Sampling inspection tables: Part I Inspection by attributes and by count of defects (*first revision*)' shall be followed for sampling inspection. The sampling plan given in 9.1.1 and 9.1.2 shall be followed for various characteristics.

9.1.1 For inspection for dimensions and workmanship and finish the sampling plan corresponding to inspection level IV and acceptable quality level ( AQL ) of 4 percent given in Tables 1 and 2 of IS : 2500 ( Part I )-1973 shall be followed.

9.1.2 For hardness and torque tests the sampling plan corresponding to inspection level I and AQL 2.5 percent given in Tables 1 and 2 of IS : 2500 ( Part I )-1973 shall be followed.

10. **Packing** — Each piece shall be wrapped in grease paper to prevent it from rusting and packed in suitable card board or box.

11. **Marking** — All screw drivers shall be marked with female hexagon ( form and nominal dimension ) manufacturer's name, initials and/or recognized trade-mark.

11.1 **ISI Certification Marking** — Details available with Indian Standards Institution.

## EXPLANATORY NOTE

While preparing this standard, assistance has been derived from DIN 7431-1968 ' Hand adapters for hexagon insert bits ' issued by Deutsches Institut für Normung ( DIN ).